

Work Order ID 56312

February 17, 2010 2:34:42 PM



Page 1

Item ID: D3224-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 2/17/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *MP*

Date: *10-2-17*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3224

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3224 11Dwg Rev: *A* 11Prog Rev: *A* 112-
Deburr if necessary

2024.663

B 10-2-23

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-2-23

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/24

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo
Debur

0.00

WLAS

Small Fab

140

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form as per Dwg D3224

GB 10/03/02 (6)

150

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

S 10/03/02

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Page 3

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Setup Start

Revision ID:

Stop

Item Name: Frame

Start Date: 2/17/10 Start Qty: 6.00

Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-03-2

6 6

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

10/03/0C

X6 0

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: _____

0.00

10-3-3 scf 6

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56312

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Page 4

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Setup Start



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Item Name: Frame

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Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 HJ
mrf
10-3-3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 56312



Parent Item: D3224-1



Parent Item Name: Frame

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

199.6696

32.8421



10-2-23

2024-T3 .063 sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

199.6696242

102942

1.5

105916

1.09

109463

0.00947368

110980

5.4854

111787

12.2847505

113866

81.3

113867

96

19059

2

113867

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

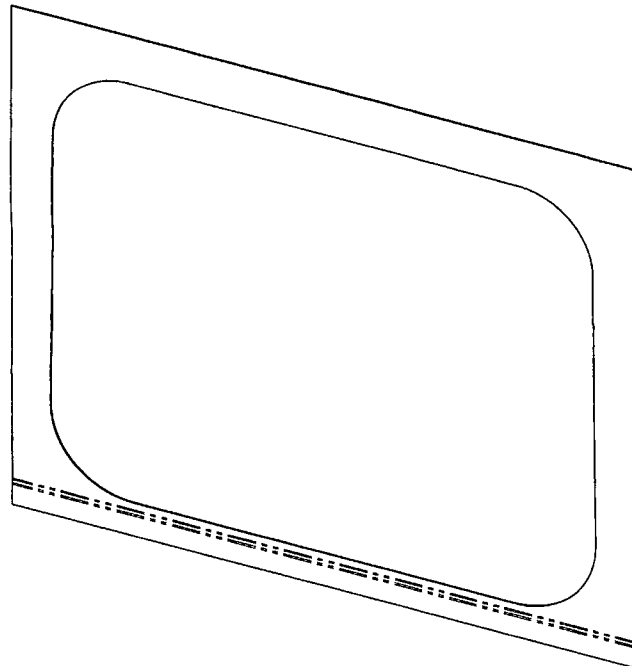
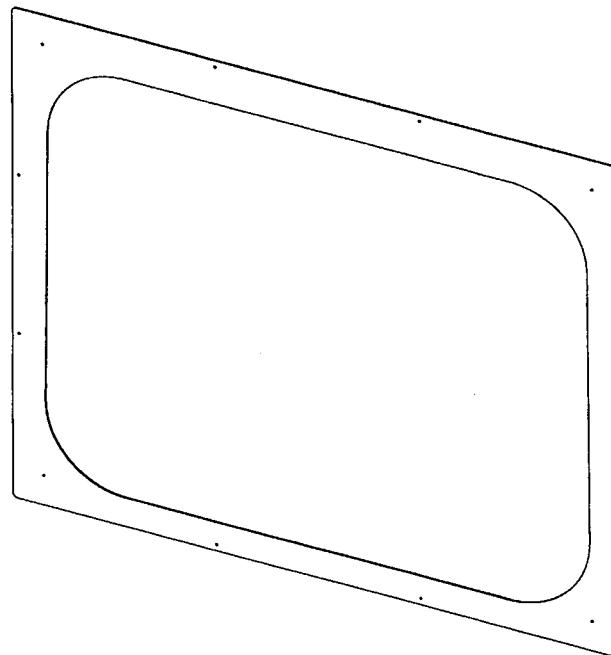
5

4

3

2

1

**D3224-1 FRAME****D3224-3 FRAME**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54312
B-10-2-17

RELEASED
07/05/13/10

NOTES:

- 1) MATERIAL: D3224-1 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037
REF. DART SPEC. M2024T3S 063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3224-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
D3224-1 = 1.40 lbs
D3224-3 = 1.22 lbs

B	REDRAWN TO CURRENT DRAWING STANDARDS; ADDED D3224-1F AND D3224-3. REASON: SEE NCR#09-054.	MB	09.05.07
A	NEW ISSUE	RF	03.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PH</i>	D3224	SHEET 1 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	FRAME	NTS
DATE	09.05.07	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

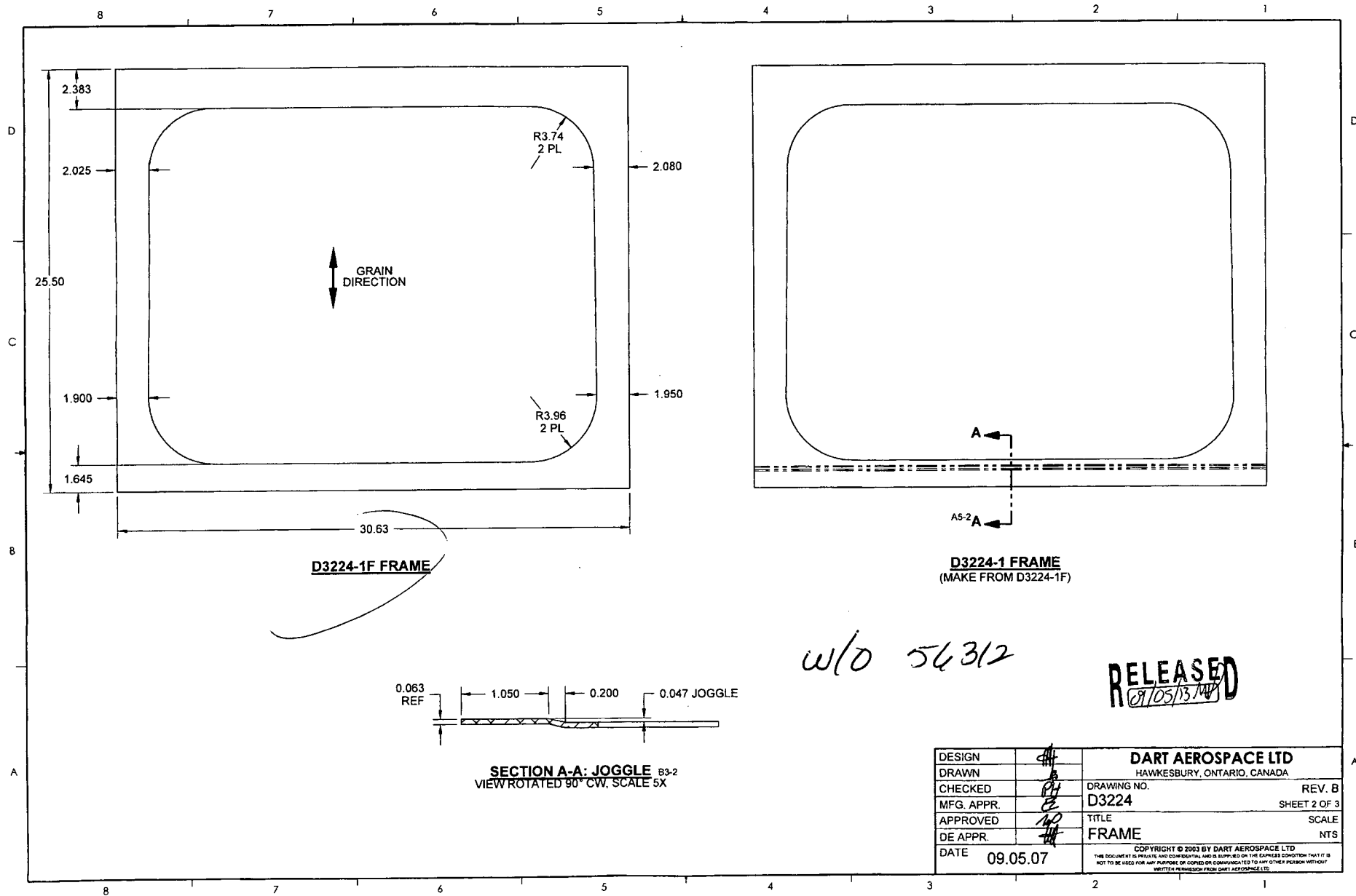
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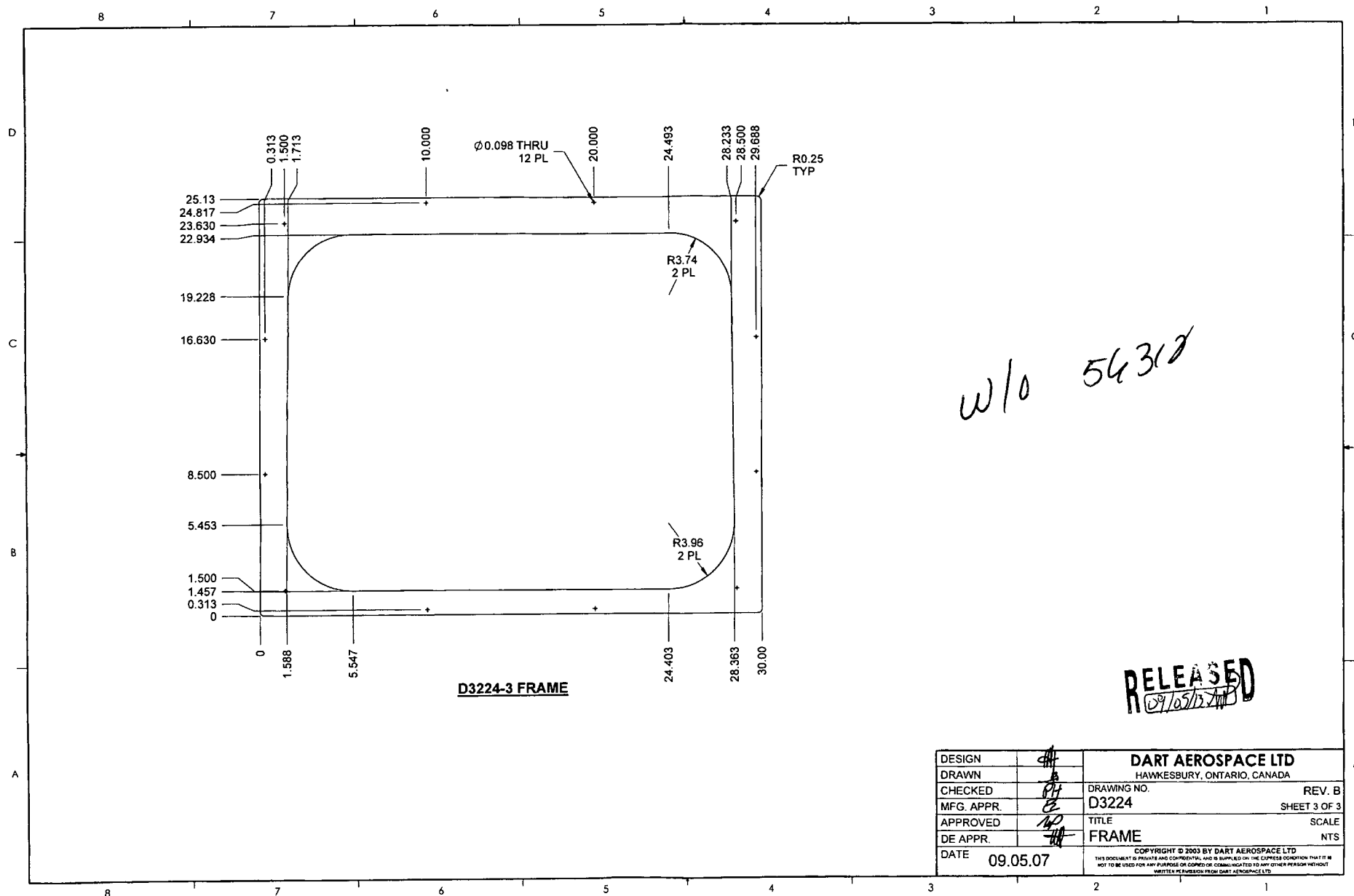
4

3

2

1





DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3224	REV. B
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		FRAME	NTS
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